

Wednesday, September 02, 2015 3:22:55 PM

136431

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/1/2015 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 9/1/2015 **Req'd Qty:** 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLS Date: SEP 03 2015

Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSK081	B

100	0.00
-----	------

100

MORI SEIKI CNC LATHE LARGE

Doosan	Memo	0.00
--------	------	------

Doosan Lathe

Memo

Turn blank as per Folio FA079

DAS
40
9-89

15/10/13

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110

QC2- Inspect parts off machine FAI/FAIB

QC	Memo	0.00
----	------	------

Quality Control

Memo

**DAS
40
9-89**

15/10/13

120	QC8- Inspect parts - second check	0.00
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120

QC8- Inspect parts - second check

QC	Memo	0.00
----	------	------

Quality Control

Memo

DAS
44
9-89

44 15/10/14
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Work Order ID 136431

136431

Page 2

Wednesday, September 02, 2015 3:22:55 PM

Item ID: DSK081 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2940-1 Turning Detail
 Start Date: 9/1/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 9/1/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS
130	Packaging					10	Ø		44
Packaging	Memo	0.00							9-89 15/10/14
Packaging	LOCATION: MAT060								
140	QC21 - Final Inspection - Work Order Release	0.00							
140									OCT 15 2015
QC	Memo	0.00							
Quality Control									

20151015


DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Wednesday, September 02, 2015 3:22:58 PM

Page 1

Work Order ID: 136431

136431

Parent Item: DSK081

DSK081

Parent Item Name: D2940-1 Turning Detail

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-007		Manufactured	No				Each	5.0000		10			DAS
D6104-007									**			15/10/08	40
Round Billet, 17-4													9-99

Location

Loc Qty

Loc Code

MAT043

5

131886

5

→ 135994

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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DART AEROSPACE LTD		Work Order:	136431
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.955	4.955	4.955	4.955	4.955
C	0.718	0.738		.728	.728	.728	.728	.728
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.573	3.573	3.573	3.573	3.573
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.453	3.453	3.453	3.453	3.453
H	0.112	0.132		.118	.118	.118	.118	.118
I	2.170	2.190		2.178	2.178	2.178	2.178	2.178
J	4.451	4.471		4.460	4.460	4.460	4.460	4.460
K	0.413	0.433		.425	.425	.425	.425	.425
L	0.913	0.933		.924	.924	.924	.924	.924
M								
N								
O								
P								

Measured by:		DAS 40	Date:	15/10/13
Audited by:		DAS 44 9-89	Date:	15/10/14
Prototype Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	136431
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	#10
Lathe Section								
A	3.211	3.216		3.216	3.216	3.216	3.216	3.216
B	4.946	4.966		4.955	4.955	4.955	4.955	4.955
C	0.718	0.738		.728	.728	.728	.728	.728
D	0.090	0.110		.100	.100	.100	.100	.100
E	3.564	3.584		3.574	3.574	3.574	3.574	3.574
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.454	3.454	3.454	3.454	3.454
H	0.112	0.132		.118	.118	.118	.118	.118
I	2.170	2.190		2.178	2.178	2.178	2.178	2.178
J	4.451	4.471		4.460	4.460	4.460	4.460	4.460
K	0.413	0.433		.425	.425	.425	.425	.425
L	0.913	0.933		.924	.924	.924	.924	.924
M								
N								
O								
P								

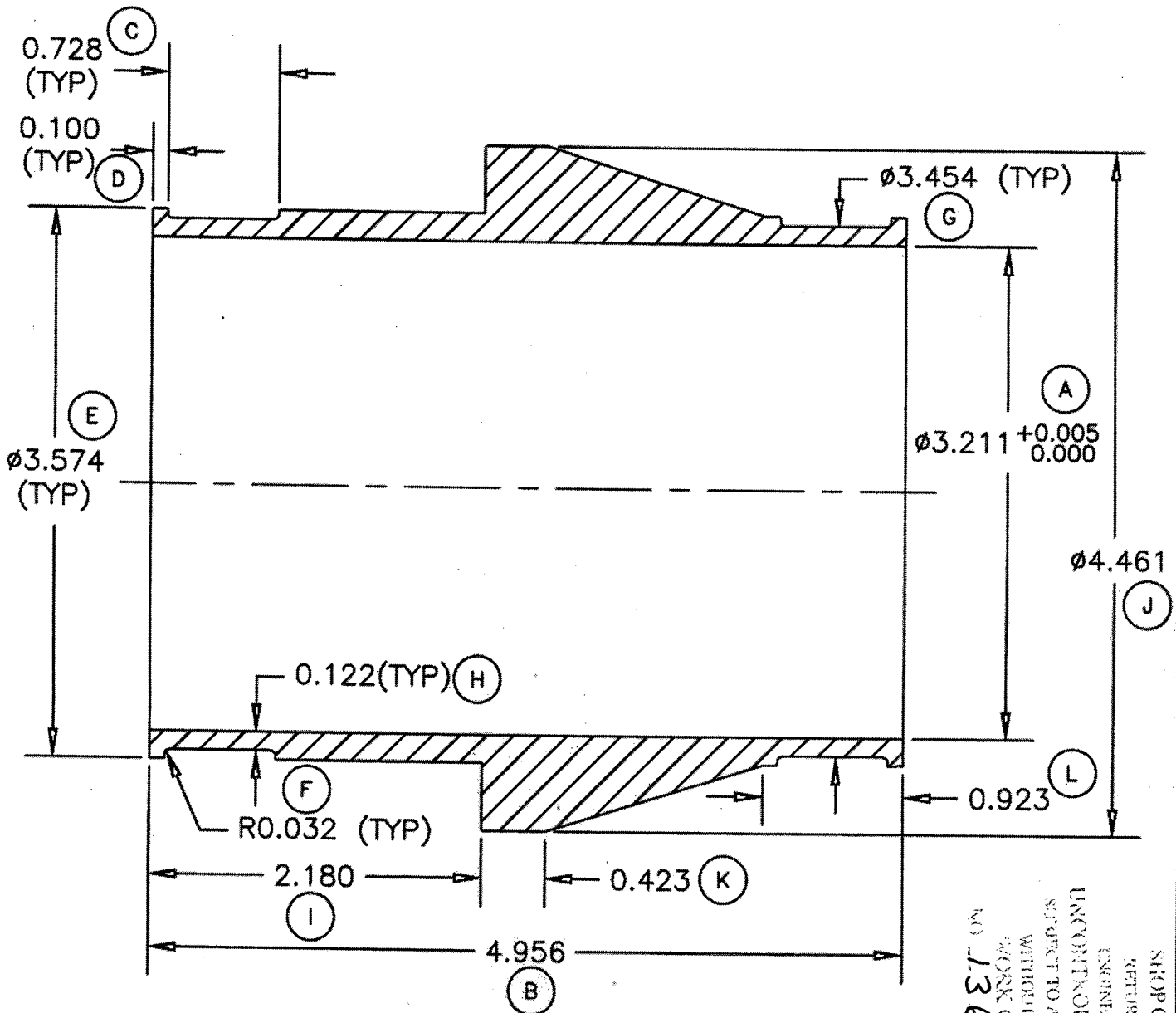
Measured by:	DAS 40	Date:	15/10/13
Audited by:	DAS 44 9-89	Date:	15/10/14
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



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DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

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